

FIG. 1

◀ AUTO PROCESS SETTING ▶

FUNCTION/TIME SETTING	FUNCTION/TIME SETTING	X 2002/12/20 0:21:20
MOVEMENT: ONE TWO THREE FOUR FIVE SIX SEVEN EIGHT NINE TEN NEXT END OF MOLD-OPENING: ▶ [02] ▶ [01] ▶ [03] ▶ [15] ▶ [04] ▶ [14] ▶ [NO] ▶ [NO] ▶ [NO] ▶ [NO] ▶ [NO] ▶ CYCLE		
MOVEMENT: ONE TWO THREE FOUR FIVE END OF MOLD-CLOSING: ▶ [NO] ▶ [01] ▶ [NO] ▶ [NO] ▶ [NO] ▶ [NO] ▶ MOLD-OPEN NO(NO MOVEMENT) [] NO(NO MOVEMENT) [] NO(NO MOVEMENT) 1.MID-EJ-BWD 1.MID-EJ-BWD 1.MID-EJ-BWD 1.MID-EJ-BWD 2.GATE-VA ON 2.GATE-VA OFF 2.GATE-VA ON 2.GATE-VA OFF		
OPTIONS AFTER END OF MOLD-CLOSING NO.NO MOVEMENT 6.CORE ONE OUT 12.ROTA-FWD CORE-1-F.B. 1.ROTATE MODE 7.CORE ONE IN ROTA-BWD CORE-2-F.B. 2.MID-EJ-FWD 8.CORE TWO OUT 13.FR-BA-EJ-BWD 3.MID-EJ-BWD 9.CORE TWO IN 14.CYC-END 4.FR-BA-EJ 10.GATE-VA OFF 15.OP-CL-DOOR 5.MID-FR-EJ 11.BATE-VA ON		NO.(NO MOVE) 1.BI-COLOR INJ. 2.FRONT INJ. 3.REAR INJ. POSITION OF ROTARY PLATE [] IN SEQUENCE []
		

FIG. 2

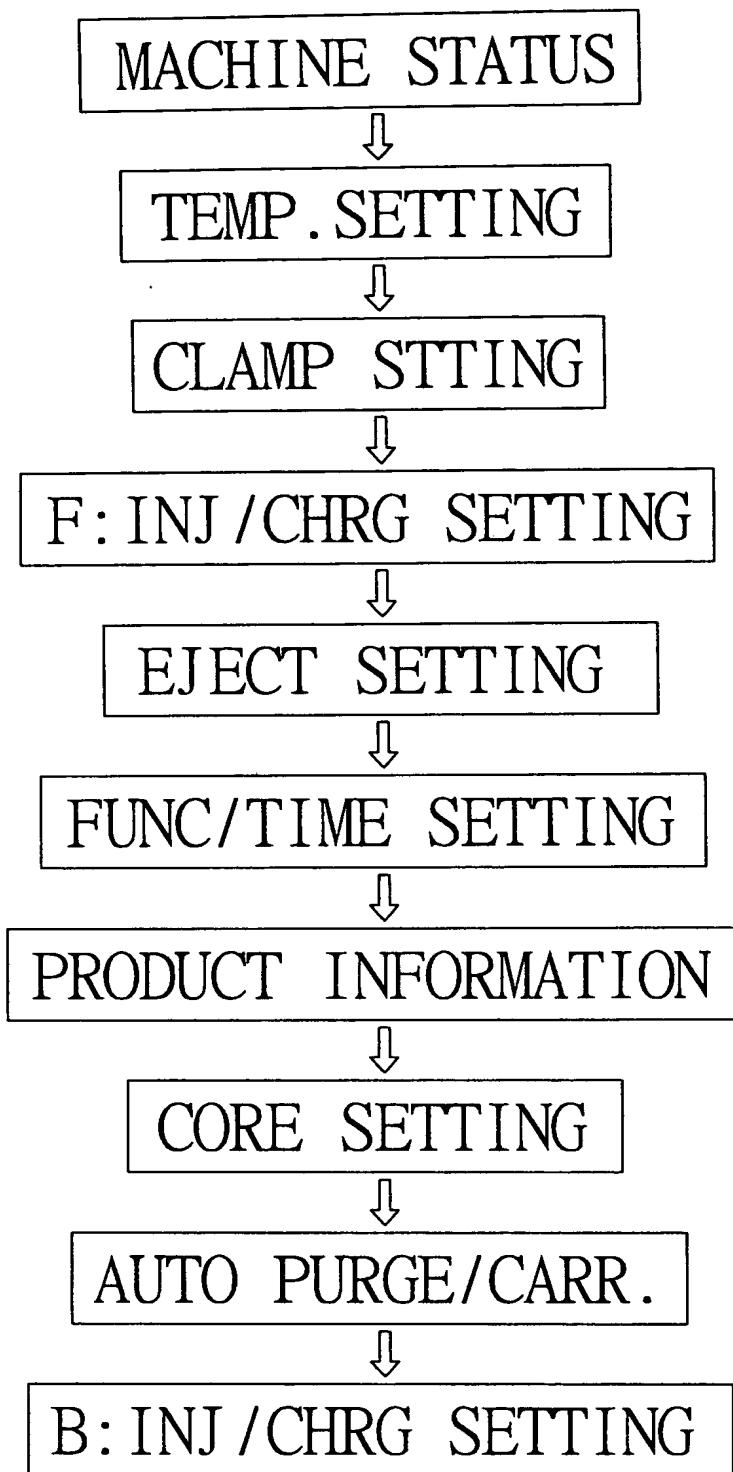
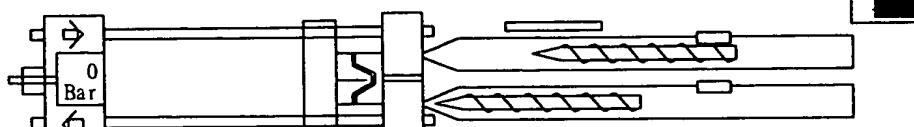


FIG. 3 (PRIOR ART)

◀ MACHINE STATUS ▶

MOLD:	MOLD1	STATION:	1	DATE:	1/27/99 11: 4:21																			
MTR:	P.P	ANG YIELD:	0.0	LAST CYCLE TIME:	0.0 S																			
FRONT	SEC1 SEC2 SEC3 SEC4 SEC5	BACK	SEC1 SEC2 SEC3 SEC4 SEC5 OIL	MOLD/MIN.	PRODUCT SUM: 10111 MD																			
CURRENT	<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0		<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0	0 °C
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				
SETTING	<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0		<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0	0 RPM
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				



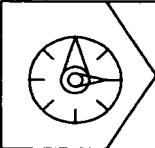
MODE: MANUAL

MOLD	0.0	F. INJ	B. INJ	F.: STP
F.EJT	0.0	POS.	0.0	F.: P: 0 Bar SPEED: 0 %
M.EJT	0.0	INJ.	0.0	B.STP
B.EJT	0.0	CRG.	0.0	B.: P: 0 Bar SPEED: 0 %
CYC.	0.0	COOL.	0.0	

FIG. 4 (PRIOR ART)

◀ TEMP. SETTING ▶

HEAT MODE:	AUTO-HEATING	MOLD:	MOLD1	MATERIAL:	P.P																			
FRONT	SEC1 SEC2 SEC3 SEC4 SEC5	BACK	SEC1 SEC2 SEC3 SEC4 SEC5 OIL																					
HEATING	200 200 200 0 0	HEATING	200 200 200 0 0																					
PREHEAT	100 100 100 0 0	PREHEAT	100 100 100 0 0																					
SCR PROT:	OFF		500		500																			
HI-DEV:	30		375		375																			
LO-DEV:	30		250		250																			
(UNIT: °C)	<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0	0	<table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr><tr><td>0</td><td>0</td><td>0</td><td>0</td><td>0</td></tr></table>	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				
0	0	0	0	0																				

	MON	TUE	WEN	THU	FRI	SAT	SUN
	HEATING	*****	*****	*****	*****	*****	*****
PREHEAT	*****	*****	*****	*****	*****	*****	*****

DATE&TIME: 1/27/99 11:10:44 DAY: MONDAY

FIG. 5 (PRIOR ART)

CLAMP SETTING

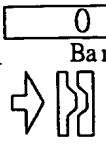
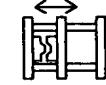
MOLD:	MOLD1	L_P_T: 0.0 S	MOLD POS: 0.0 mm																								
CLAMP-P  Bar	<table border="1"> <thead> <tr> <th></th> <th>FAST</th> <th>SLOW</th> <th>L-P</th> <th>H-P</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>30</td> <td>1</td> <td>140</td> <td>99</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>99</td> <td>50</td> <td>40</td> <td>99</td> <td>%</td> </tr> <tr> <td>POS.</td> <td>160</td> <td>100</td> <td></td> <td>0.5</td> <td>mm</td> </tr> </tbody> </table>				FAST	SLOW	L-P	H-P		PRES	30	1	140	99	Bar	SPEED	99	50	40	99	%	POS.	160	100		0.5	mm
	FAST	SLOW	L-P	H-P																							
PRES	30	1	140	99	Bar																						
SPEED	99	50	40	99	%																						
POS.	160	100		0.5	mm																						
L_P_PROT: 6.0 sec FAST CLAMP: OFF CLAMP FORCE: 360 TON																											
OPEN 	<table border="1"> <thead> <tr> <th></th> <th>DEC.</th> <th>MID</th> <th>FAST</th> <th>SLOW</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>30</td> <td>30</td> <td>30</td> <td>140</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>99</td> <td>50</td> <td>40</td> <td>99</td> <td>%</td> </tr> <tr> <td>POS.</td> <td>600</td> <td>540</td> <td>50</td> <td>50</td> <td>mm</td> </tr> </tbody> </table>				DEC.	MID	FAST	SLOW		PRES	30	30	30	140	Bar	SPEED	99	50	40	99	%	POS.	600	540	50	50	mm
	DEC.	MID	FAST	SLOW																							
PRES	30	30	30	140	Bar																						
SPEED	99	50	40	99	%																						
POS.	600	540	50	50	mm																						
OP-LIM.: 1000 mm OP_MD_PROT: 5.0 sec SPRING MOLD: OFF																											
MOLD-ADJ. 	<table border="1"> <thead> <tr> <th></th> <th>MV-BWD</th> <th>CLAMP</th> <th>MV-FWD</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>40</td> <td>40</td> <td>40</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>30</td> <td>20</td> <td>30</td> <td>%</td> </tr> <tr> <td>PS</td> <td>0</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				MV-BWD	CLAMP	MV-FWD		PRES	40	40	40	Bar	SPEED	30	20	30	%	PS	0							
	MV-BWD	CLAMP	MV-FWD																								
PRES	40	40	40	Bar																							
SPEED	30	20	30	%																							
PS	0																										

FIG. 6(PRIOR ART)

F: INJ / CHRG SETTING

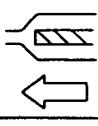
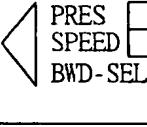
CHRG LIMIT: 470.0 mm		INJ. POS.: 0.0																																			
INJECTION USE: OFF	SUCK MODE: OFF	COOL TM: 0.0																																			
INJECTION 	<table border="1"> <thead> <tr> <th></th> <th>HOLD2</th> <th>HOLD1</th> <th>INJ 3</th> <th>INJ 2</th> <th>INJ 1</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>0</td> <td>10</td> <td>0</td> <td>0</td> <td>60</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>0</td> <td>20</td> <td></td> <td></td> <td>80</td> <td>%</td> </tr> <tr> <td>TIME</td> <td>0.0</td> <td>0.5</td> <td></td> <td>0.60</td> <td></td> <td>sec</td> </tr> <tr> <td>POS.</td> <td>*****</td> <td></td> <td>0.01</td> <td>0.0</td> <td>10.0</td> <td>mm</td> </tr> </tbody> </table>			HOLD2	HOLD1	INJ 3	INJ 2	INJ 1		PRES	0	10	0	0	60	Bar	SPEED	0	20			80	%	TIME	0.0	0.5		0.60		sec	POS.	*****		0.01	0.0	10.0	mm
	HOLD2	HOLD1	INJ 3	INJ 2	INJ 1																																
PRES	0	10	0	0	60	Bar																															
SPEED	0	20			80	%																															
TIME	0.0	0.5		0.60		sec																															
POS.	*****		0.01	0.0	10.0	mm																															
SHRG 	<table border="1"> <thead> <tr> <th></th> <th>CHRG1</th> <th>CHRG2</th> <th>POSTSCK</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>0</td> <td>0</td> <td>40</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>0</td> <td>99</td> <td>40</td> <td>%</td> </tr> <tr> <td>SYS-PRES</td> <td>0</td> <td></td> <td>Bar</td> <td></td> </tr> <tr> <td>POS.</td> <td>0.0</td> <td>100.0</td> <td>+ 0</td> <td>mm</td> </tr> </tbody> </table>			CHRG1	CHRG2	POSTSCK		PRES	0	0	40	Bar	SPEED	0	99	40	%	SYS-PRES	0		Bar		POS.	0.0	100.0	+ 0	mm										
	CHRG1	CHRG2	POSTSCK																																		
PRES	0	0	40	Bar																																	
SPEED	0	99	40	%																																	
SYS-PRES	0		Bar																																		
POS.	0.0	100.0	+ 0	mm																																	
INJ. STL MODE: POS. or TM																																					
CARR 	<table border="1"> <thead> <tr> <th></th> <th>FWD</th> <th>BWD</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>20</td> <td>20</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>20</td> <td>20</td> <td>%</td> </tr> <tr> <td>BWD-SEL</td> <td></td> <td>OFF</td> <td></td> </tr> </tbody> </table>		FWD	BWD		PRES	20	20	Bar	SPEED	20	20	%	BWD-SEL		OFF		<table border="1"> <thead> <tr> <th></th> <th>PRE TEST</th> <th>ACC USE</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td>OFF</td> <td>OFF</td> </tr> <tr> <td>SPEED</td> <td>0</td> <td>10 Bar</td> </tr> <tr> <td></td> <td>0</td> <td>0 %</td> </tr> <tr> <td></td> <td>0.0</td> <td></td> </tr> </tbody> </table>		PRE TEST	ACC USE	PRES	OFF	OFF	SPEED	0	10 Bar		0	0 %		0.0					
	FWD	BWD																																			
PRES	20	20	Bar																																		
SPEED	20	20	%																																		
BWD-SEL		OFF																																			
	PRE TEST	ACC USE																																			
PRES	OFF	OFF																																			
SPEED	0	10 Bar																																			
	0	0 %																																			
	0.0																																				

FIG. 7(PRIOR ART)

EJECT SETTING

S-EJ-F POS.: 0. 0	EJ-M POS.: 0. 0	S-EJ-B POS.: 0. 0 mm																				
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">ROTA STOP</td> <td style="width: 33%;">ROTA-B</td> <td style="width: 33%;">ROTA-S</td> </tr> <tr> <td>PRES 0</td> <td>140</td> <td>140</td> </tr> <tr> <td>SPEED 0</td> <td>0</td> <td>0 %</td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">EJ-FW1</td> <td style="width: 50%;">EJ-FW2</td> </tr> <tr> <td>PRES 40</td> <td>40 Bar</td> </tr> <tr> <td>SPEED 60</td> <td>60 %</td> </tr> <tr> <td>POS. 0. 0</td> <td>0. 0 mm</td> </tr> </table>			ROTA STOP	ROTA-B	ROTA-S	PRES 0	140	140	SPEED 0	0	0 %	EJ-FW1	EJ-FW2	PRES 40	40 Bar	SPEED 60	60 %	POS. 0. 0	0. 0 mm			
ROTA STOP	ROTA-B	ROTA-S																				
PRES 0	140	140																				
SPEED 0	0	0 %																				
EJ-FW1	EJ-FW2																					
PRES 40	40 Bar																					
SPEED 60	60 %																					
POS. 0. 0	0. 0 mm																					
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">F. S-EJ-B</td> <td style="width: 50%;">S-EJ-F</td> </tr> <tr> <td>PRES 0</td> <td>0</td> </tr> <tr> <td>SPEED 0</td> <td>0</td> </tr> <tr> <td>POS. 0. 0</td> <td>0. 0</td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">B. S-EJ-B</td> <td style="width: 50%;">S-EJ-F</td> </tr> <tr> <td>PRES 0</td> <td>0</td> </tr> <tr> <td>SPEED 0</td> <td>0</td> </tr> <tr> <td>POS. 0. 0</td> <td>0. 0</td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 100%;">EJ-BWD</td> </tr> <tr> <td>PRES 60 Bar</td> </tr> <tr> <td>SPEED 60 %</td> </tr> <tr> <td>POS. 0. 0 mm</td> </tr> </table>			F. S-EJ-B	S-EJ-F	PRES 0	0	SPEED 0	0	POS. 0. 0	0. 0	B. S-EJ-B	S-EJ-F	PRES 0	0	SPEED 0	0	POS. 0. 0	0. 0	EJ-BWD	PRES 60 Bar	SPEED 60 %	POS. 0. 0 mm
F. S-EJ-B	S-EJ-F																					
PRES 0	0																					
SPEED 0	0																					
POS. 0. 0	0. 0																					
B. S-EJ-B	S-EJ-F																					
PRES 0	0																					
SPEED 0	0																					
POS. 0. 0	0. 0																					
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PRES 60 Bar																						
SPEED 60 %																						
POS. 0. 0 mm																						
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">EJECT MODE: REPEATED</td> <td style="width: 33%;">ROTA MODE: OFF</td> <td style="width: 33%;">AIR EJECT: OFF</td> </tr> <tr> <td>EJC DELAY: 0. 0 s</td> <td>S-EJ MODE: OFF</td> <td>MV-MD EJ POS.: 100 mm</td> </tr> <tr> <td>HOLD TIME: 0. 0 s</td> <td>S-EJ-F TI.: 0</td> <td>FIXED-MD EJ TM: 2. 0 sec</td> </tr> <tr> <td>EJC TIMES: 3</td> <td>S-EJ-B TI.: 0</td> <td>MV-MD EJ TM: 2. 0 sec</td> </tr> <tr> <td>FIXED EJC: OFF</td> <td>MASK TIME: OFF</td> <td>CLP-END-EJ: OFF</td> </tr> <tr> <td></td> <td>PHOTOCELL: OFF</td> <td></td> </tr> </table>			EJECT MODE: REPEATED	ROTA MODE: OFF	AIR EJECT: OFF	EJC DELAY: 0. 0 s	S-EJ MODE: OFF	MV-MD EJ POS.: 100 mm	HOLD TIME: 0. 0 s	S-EJ-F TI.: 0	FIXED-MD EJ TM: 2. 0 sec	EJC TIMES: 3	S-EJ-B TI.: 0	MV-MD EJ TM: 2. 0 sec	FIXED EJC: OFF	MASK TIME: OFF	CLP-END-EJ: OFF		PHOTOCELL: OFF			
EJECT MODE: REPEATED	ROTA MODE: OFF	AIR EJECT: OFF																				
EJC DELAY: 0. 0 s	S-EJ MODE: OFF	MV-MD EJ POS.: 100 mm																				
HOLD TIME: 0. 0 s	S-EJ-F TI.: 0	FIXED-MD EJ TM: 2. 0 sec																				
EJC TIMES: 3	S-EJ-B TI.: 0	MV-MD EJ TM: 2. 0 sec																				
FIXED EJC: OFF	MASK TIME: OFF	CLP-END-EJ: OFF																				
	PHOTOCELL: OFF																					

FIG. 8(PRIOR ART)

FUNC/TIME SETTING

<p>FUNC SWITCH</p> 	<p>ROBAT</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>CHRG-AFT-COOLING</td> <td>ON</td> </tr> <tr> <td>EXHAUST</td> <td>OFF</td> </tr> <tr> <td>REV.</td> <td>OFF</td> </tr> <tr> <td></td> <td>OFF</td> </tr> </table>	CHRG-AFT-COOLING	ON	EXHAUST	OFF	REV.	OFF		OFF	<p>P-PRE-TEST</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>PRES</td> <td>OFF</td> </tr> <tr> <td>SPEED</td> <td>50 Bar</td> </tr> <tr> <td></td> <td>50 %</td> </tr> </table>	PRES	OFF	SPEED	50 Bar		50 %																														
CHRG-AFT-COOLING	ON																																													
EXHAUST	OFF																																													
REV.	OFF																																													
	OFF																																													
PRES	OFF																																													
SPEED	50 Bar																																													
	50 %																																													
<p>TIMER SETTING</p> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>CYCLE ALM</td> <td>60.0</td> <td>sec</td> <td>RECYCLE DELAY</td> <td>0.1</td> <td>sec</td> </tr> <tr> <td>INJECT ALM</td> <td>30.0</td> <td>sec</td> <td>ABNDRMAL TIME</td> <td>60.0</td> <td>sec</td> </tr> <tr> <td>CHARGE ALM</td> <td>30.0</td> <td>sec</td> <td>PHOTOCELL</td> <td>6.0</td> <td>sec</td> </tr> <tr> <td>MIDDLE ALM</td> <td>360.0</td> <td>sec</td> <td>EXHAUST TM</td> <td>0.1</td> <td>sec</td> </tr> <tr> <td>POWER DOOR OPN</td> <td>3.0</td> <td>sec</td> <td>F. CHARGE ALM</td> <td>0.1</td> <td></td> </tr> <tr> <td>F. INJECT ALM</td> <td>0.1</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	CYCLE ALM	60.0	sec	RECYCLE DELAY	0.1	sec	INJECT ALM	30.0	sec	ABNDRMAL TIME	60.0	sec	CHARGE ALM	30.0	sec	PHOTOCELL	6.0	sec	MIDDLE ALM	360.0	sec	EXHAUST TM	0.1	sec	POWER DOOR OPN	3.0	sec	F. CHARGE ALM	0.1		F. INJECT ALM	0.1					<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>ST_NO:</td> <td>1</td> </tr> <tr> <td>BAUD:</td> <td>9600 BPS</td> </tr> <tr> <td>PROTOCOL:</td> <td>PIS</td> </tr> <tr> <td>COM_FUN:</td> <td>DISABLE</td> </tr> </table>	ST_NO:	1	BAUD:	9600 BPS	PROTOCOL:	PIS	COM_FUN:	DISABLE
CYCLE ALM	60.0	sec	RECYCLE DELAY	0.1	sec																																									
INJECT ALM	30.0	sec	ABNDRMAL TIME	60.0	sec																																									
CHARGE ALM	30.0	sec	PHOTOCELL	6.0	sec																																									
MIDDLE ALM	360.0	sec	EXHAUST TM	0.1	sec																																									
POWER DOOR OPN	3.0	sec	F. CHARGE ALM	0.1																																										
F. INJECT ALM	0.1																																													
ST_NO:	1																																													
BAUD:	9600 BPS																																													
PROTOCOL:	PIS																																													
COM_FUN:	DISABLE																																													

FIG. 9(PRIOR ART)

◀ PRODUCT INFORMATION ▶

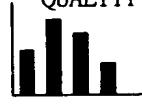
QUALITY CTL 	MATERIAL: [REDACTED]	MOLD: MOLD1	<input type="button" value="SAVE"/>			
	MOLD SEARCH:		<input type="button" value="LOAD"/> <input type="button" value="CLEAR"/>			
	POWER TIME: 0 HR AUTO-WORK T 0.0 HR					
PROD_TAR CURR_NO STOP_SEL	TOTAL_NO 1000	GOOD_NO 1000	BAD_NO 20	CAVITY_NO 5	BOX NUMBER 1	MOLD WEIGHT MD 8.8 G
	10111	20222	123	CNT_BAD	0	MD PCS WT
	OFF	OFF	OFF	OFF	OFF	1.0 G
	CNTR RES	BAD RST			RESET	
CUSHION Q.C. VALUE TOLERANCE MEAN STD DEV. SELECT	0.0 mm 11.0 mm 3.0 mm 0.0 mm 0.0 mm OFF	INJ. TM 6.00 1.50 0.00 0.00 OFF	CHRG TM 10.0 2.0 0.0 0.0 OFF	CYCLE TM 30.0 sec 2.0 sec 0.0 sec 0.0 sec OFF		

FIG. 10(PRIOR ART)

◀ CORE SETTING ▶

MOLD POS.: 0.5 mm

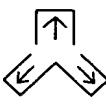
CORE 1 	Type: CORE	CORE-IN	CORE-OUT1	CORE-OUT2
	SELECT	OFF	OFF	OFF
	PRES	40	40	40
	SPEED	40	40	40
	POS.	300	0	600
	TIME	0.0	0.0	0.0
	TEETH	1	1	1
CORE 2 	Type: CORE	CORE-IN	CORE-OUT1	CORE-OUT2
	SELECT	OFF	OFF	OFF
	PRES	40	40	40
	SPEED	40	40	40
	POS.	299	1	600
	TIME	0.0	0.0	0.0
	TEETH	1	1	1
SENSOR SW	OFF	OFF	OFF	

FIG. 11(PRIOR ART)

◀ AUTO PURGE/CARR. ▶

B. INJECT POS.: 0. 0	F. INJECT POS.: 0. 0 mm																									
<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td rowspan="4" style="width: 20%; vertical-align: top;">AUTO PURGE</td> <td colspan="2">REPEATED-SEL: ■ B. INJ</td> <td colspan="2">REPEATED TIME: 5</td> </tr> <tr> <td>SLOW</td> <td>FAST</td> <td>SUCKBACK</td> <td>CHARGE</td> </tr> <tr> <td>40</td> <td>40</td> <td>PRES 40</td> <td>50</td> </tr> <tr> <td>20</td> <td>60</td> <td>SPEED 30</td> <td>50</td> </tr> <tr> <td colspan="2">mm</td> <td colspan="2">mm sec</td> </tr> <tr> <td colspan="2">11. 0 30. 0</td> <td colspan="2">60 0. 0</td> </tr> </table>		AUTO PURGE	REPEATED-SEL: ■ B. INJ		REPEATED TIME: 5		SLOW	FAST	SUCKBACK	CHARGE	40	40	PRES 40	50	20	60	SPEED 30	50	mm		mm sec		11. 0 30. 0		60 0. 0	
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BWD-SEL ON																										

FIG. 12(PRIOR ART)

◀ B: INJ / CHRG SETTING ▶

CHRG LIMIT: 470.0 mm		INJ. POS.: 0. 0 mm																																																
INJECTION USE.: ■ OFF		SUCK MODE: ON COOL TM: 3.0 sec																																																
<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td rowspan="4" style="width: 20%; vertical-align: top;">INJECT</td> <td>INJ 5</td> <td>INJ 4</td> <td>INJ 3</td> <td>INJ 2</td> <td>INJ 1</td> </tr> <tr> <td>PRES 0</td> <td>0</td> <td>20</td> <td>60</td> <td>111</td> </tr> <tr> <td>SPEED 0</td> <td>0</td> <td>20</td> <td>99</td> <td>99</td> </tr> <tr> <td>POS. 0. 0</td> <td>*****</td> <td>10. 0</td> <td>50. 0</td> <td>96. 0</td> </tr> <tr> <td colspan="5">mm sec</td> </tr> <tr> <td colspan="5">TIME 0. 00</td> </tr> </table>		INJECT	INJ 5	INJ 4	INJ 3	INJ 2	INJ 1	PRES 0	0	20	60	111	SPEED 0	0	20	99	99	POS. 0. 0	*****	10. 0	50. 0	96. 0	mm sec					TIME 0. 00					<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td colspan="4">INJ. CTL MODE:</td> </tr> <tr> <td colspan="4">POS. or TM</td> </tr> <tr> <td colspan="4">4-CYLINDER:</td> </tr> <tr> <td colspan="4">NORMAL-V</td> </tr> </table>		INJ. CTL MODE:				POS. or TM				4-CYLINDER:				NORMAL-V			
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FIG. 13(PRIOR ART)